

SHIP 20/07 Monday

9039

Work Order ID 50631

July 17, 2009 12:38:19 PM

Item ID: D2282-041

Accept

Revision ID: E

Item Name: T Assembly

Setup Start

Stop

Start Date: 7/17/09 Start Qty: 5.00

Required Date: 7/20/09 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-041 'T' Handle Assembly. Grind chamfers and ensure full penetration as per dwg D2282. *****brush weld right after welding, to take color off *****A/RER316L SS Filling Rod

M 102421

SP 09.07.17

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

09/07/17

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble

1 ulh 5

Work Order ID 50631

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Page 2

Item ID: D2282-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: T Assembly

Start Date: 7/17/09

Start Qty: 5.00



Cust Item ID:

Required Date: 7/20/09

Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

=> 8 09/07/17 (45) f

09/17/17 (5)

09/07/2009

W 09.07.17

Picklist Print

July 17, 2009 12:38:18 PM

Work Order ID: 50631

Parent Item: D2282-041RevE

Parent Item Name: T Assembly

Comments:

Start Date: 7/17/09

Required Date: 7/20/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2282-3RevE Manufactured

No

100

Each

84.0000

5.0000



Tube

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

84

46428

30

46689

4

48279

50

1

4

Sp 09.07.20

D2282-5RevE Manufactured

No

100

Each

118.0000

5.0000



Tube

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

118

46429

73

48281

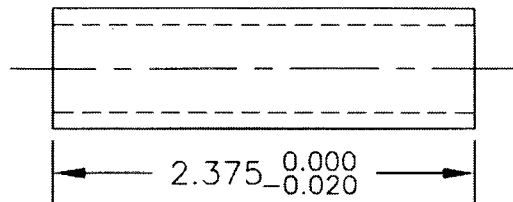
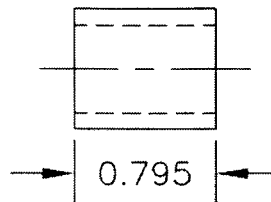
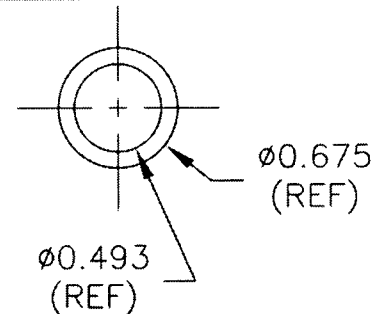
45

5

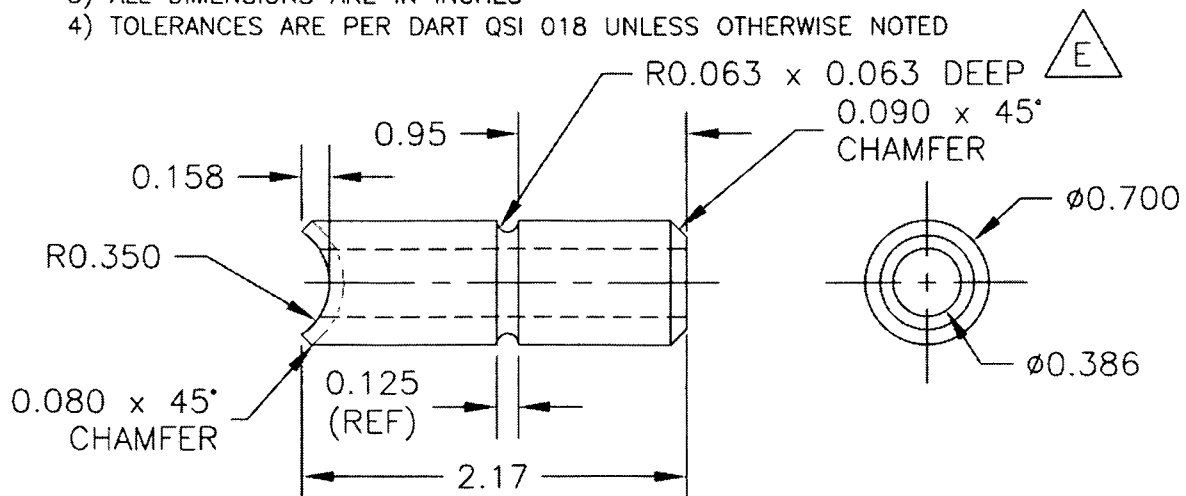
Sp 09.07.20

DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

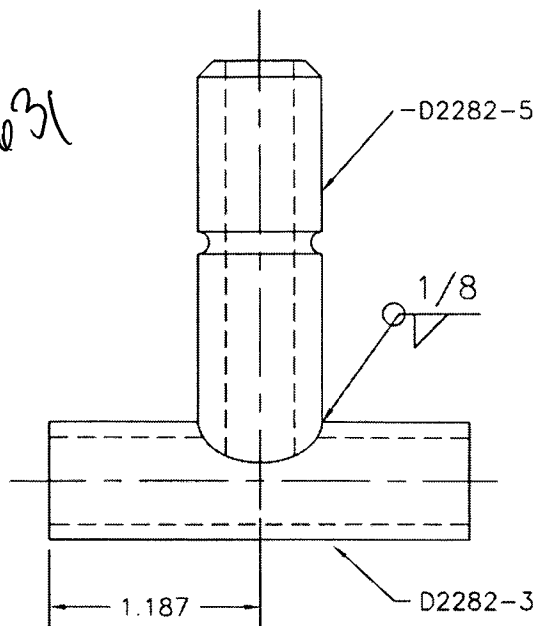
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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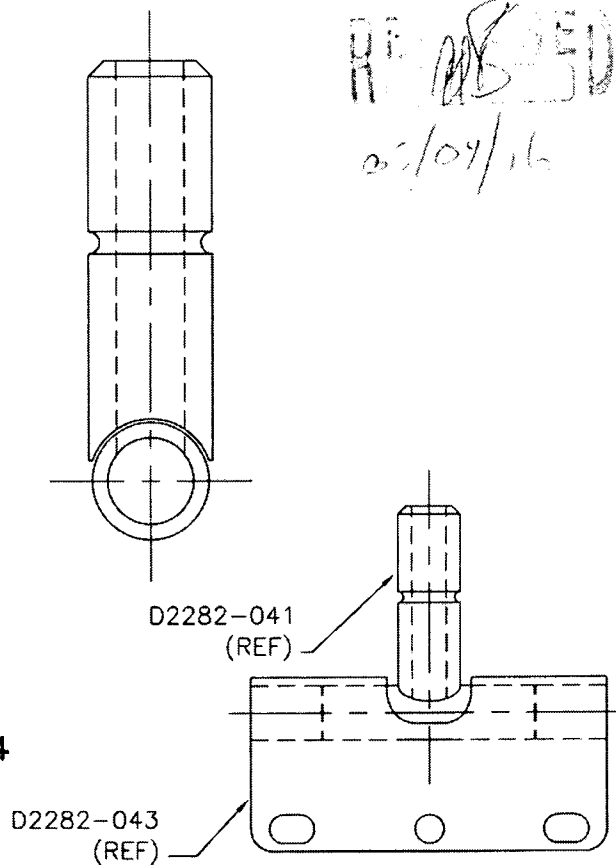
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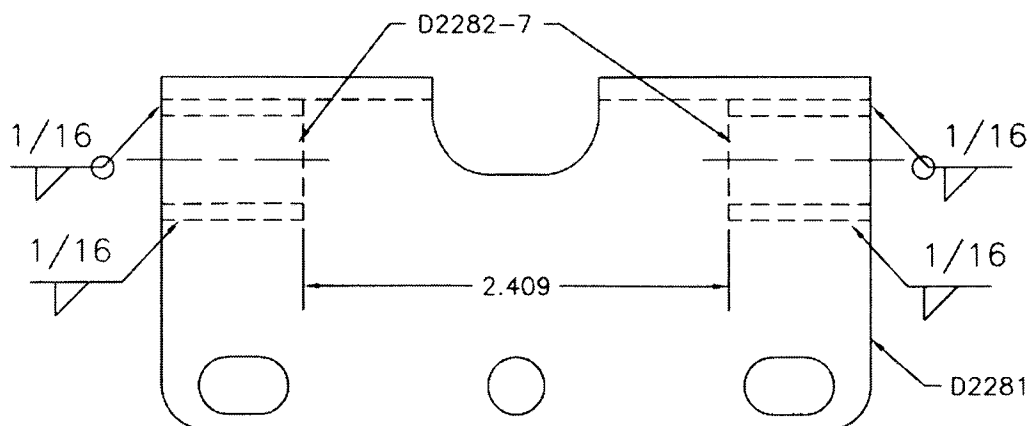
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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